



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T102146-101
Job Sheet 175834



Part No: RB T102146-101

Job Qty: 2 ea

Part Name: Plate Set



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/25/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG RB T102146-101 Rev 0 IPP Rev A 18.03.09 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		4/25/18	0.00	0.00	Purchasing		A1810V17
110	Packaging	2 pcs		4/25/18	0.00	0.00	Packaging2		A1810V17
120	QC	2 pcs		4/25/18	0.00	0.00	QC6		38
130	Packaging	2 pcs		4/25/18	0.00	0.00	Packaging3		18-04-19
140	QC21-FG	2 Ea		4/25/18	0.00	0.00	QC21		GA150

Part Op 100 - Issue P/O: 39577 MANUFACTURE RB T102146-101 AS PER DWG Supplier: AIRCRAFT HARDWARE
Descriptions: ACCESS -Certificate of conformity is required

APR 11 2018

DAS
13
9-09

X 2

APR 20 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T102146-101P	PLATE SET ASSY	2 pcs (1 ea)	100-Purchasing	5062089

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T102146-101P	2	2	0

Part Specifications

Specifications could not be found.

Plex 4/11/18 8:52 AM dart.lavoie.chantal

Container No. 0002000



Plate Set

PART NO: RB T102146 – 101

Serial No/Batch: S062090

Revision:

Operation: Packaging

Change No:

Mfg Date: 04/17/18

Job No: 175834

Chantal Lavoie

From: Robert Aboud
Sent: Tuesday, April 10, 2018 3:24 PM
To: Chantal Lavoie
Subject: FW: T102146-101

Chantal,

Order 2 more from Stan please

Rob Aboud

Director of Supply Chain

DART AEROSPACE

T 1-613-632-5200 Ext.244

M 1-514-979-6138

www.dartaerospace.com



From: sales@aircrafthardwareaccs.com <sales@aircrafthardwareaccs.com>
Sent: Tuesday, April 10, 2018 3:22 PM
To: Robert Aboud <raboud@dartaero.com>
Subject: RE: T102146-101

yes

From: Robert Aboud <raboud@dartaero.com>
Sent: Tuesday, April 10, 2018 1:11 PM
To: sales@aircrafthardwareaccs.com
Subject: T102146-101

Hi Stan,

Do you have 2 more of these?

Last purchased on PO 039264

Thanks

Rob Aboud

Director of Supply Chain

DART AEROSPACE

T 1-613-632-5200 Ext.244

M 1-514-979-6138

www.dartaerospace.com



4/11/2018

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039577**

Supplier: AIH001-VU
Aircraft Hardware and Accessories
P.O. Box 14007
Ft Worth, TX 76617 USA

PO No: PO039577**PO Date:** 4/11/18**Due Date:** 4/18/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
 Phone: clavoie@dartaero.com

Pymt Terms: Net 30**Freight Terms:****Special Comments:**

E-MAILED
 APR 11 2018

Ship To: 1270 Aberdeen Street
 Hawkesbury
 ON
 K6A 1K7 Canada
 Phone: 613-632-5200

Items

Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RB T102146-101P		PLATE SET ASSY As Per Dwg T102146-101	Firmed	4/18/18	2 pcs	0 pcs 12x	2 pcs	\$1,000.00/pcs	\$2,000.00
Grand Total:										\$2,000.00

Order Notes

Procurement Quality Clauses
 A005 RIGHT OF ENTRY
 A016 PERSONNEL QUALIFICATION
 A026 CERTIFICATION OF MATERIAL CONFORMANCE
 A032 PUBLIC LAW 101-592 FASTENER QUALITY ACT
 A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
 A040 NOTIFICATION OF QUALITY ESCAPE
 A041 QUALITY MANAGEMENT SYSTEM
 A042 DART NOTIFICATION BY SUPPLIER
 A043 RETENTION OF QUALITY DOCUMENTS
 A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
 A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/11/18 12:48 PM dart.lavoie.chantal

AIRCRAFT HARDWARE & ACCES.
P.O. BOX 14007 FT. WORTH TX 76117
Phone: 817-680-3523 FAX- 817-416-5274
e-mail: sales@aircrafthardwareacces.com

Packing Slip

ATTN: Shipping Dept.

Date: 4/12/2018

TO: DART AEROSPACE

1270 ABERDEEN STREET

Hawkesbury ON K6A1K7

Packer # 41218A

Cust. PO #: SEE BELOW

Qty	Tool #	REF#	Description
1	RBT103211-101	PO#39086	LIFT COVER PLATE
2	RBT101972	PO#39564	HOLDING PLATE
2	RBT102146-101	PO#39577	PLATE SET
1	RBT103140-101	PO#39264	LIFT COVER PLATE
5	RBT101402	PO#38915	LINKS

ALL MATERIALS, PARTS OR COMPONENTS HAVE BEEN INSPECTED
AND COMPLY WITH THE PURCHASE ORDER REQUIREMENTS

Eugene ALL 8/8/19

Reynolds Aluminum	yes
Ryerson	no
Tube Service	yes
Tubular Solutions Inc.	yes

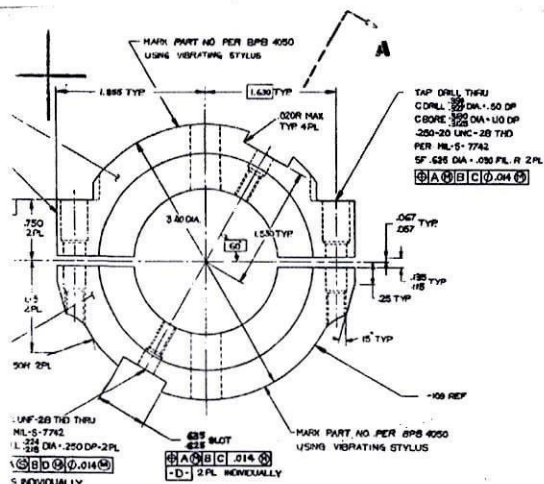
Hardware

A-1 Coupling	yes
Aircraft Hardware & Acc	yes
Aircraft Spruce	Yes
Aircraft Supply & Repair	yes
Allied Aerospace	yes
Applied Industrial	yes
Aviall, Central Whse	yes
Bisco Industries Inc	yes
DGI Supply - A Doall Company	yes
Doall-Carr Lane	Yes
Elesa USA Corp	yes
EROWA Technology	yes
Essentra Components	yes
Eugene Fastner	yes
Herber Aircraft Service Inc	yes
J.W. WINCO	YES
Jeffers.com	yes
JW Winco	yes
Kaman	yes
Kong USA	yes
Mcmaster Carr	yes
MiSumi USA	yes
Motion & Flow Control Products Inc	yes
MSC Industrial Supply	yes
NORELEM	yes

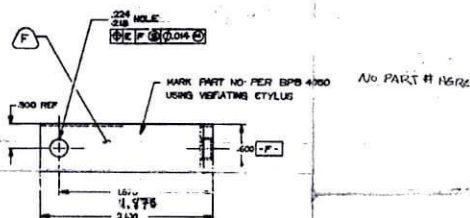
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BY ATTY. GEN. I
ON MARCH

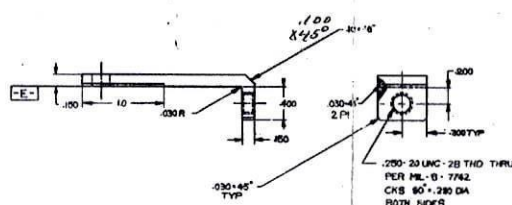
SECTION A-A



DETAIL OF - 103 PLATE SET



DETAIL OF -105 CLIP



FILE COPY

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PROPERTY RIGHTS NOTICE THESE RIGHTS ARE RESERVED TO THE MANUFACTURER. THE USER SHALL BE RESPONSIBLE FOR THE PROTECTION OF THE RIGHTS OF THE MANUFACTURER. THE USER SHALL NOT BE HELD RESPONSIBLE FOR THE PROTECTION OF THE RIGHTS OF THE MANUFACTURER. THE USER SHALL NOT BE HELD RESPONSIBLE FOR THE PROTECTION OF THE RIGHTS OF THE MANUFACTURER.		SHIP CODE FOR NAME SEE 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 100	
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100	100	100

013.44



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Inventory Type
Part Number: RB T102146-101 Revision: Plate Set																
140	QC21-FG	S062090	175834		2 Ea	0	S062090	GA150	Bin	Stock	4/17/2018					False
Operation Totals:		1			2	0										
Part Totals:		1			2	0										
Totals:		1			2	0										

Plex 4/25/2018 10:54 AM Dart.Downing.Eric

1. PART NO: T102146-105		B/P REV. C	2. PART NAME: CLIP		3. SERIAL NO. N/A	4. FAI RPT NO./REV. BSC	
5. MATERIAL OR PROCESS NAME		6. SPECIFICATION NUMBER	7. CODE	8. SPECIAL PROCESS SUPPLIER CODE	9. CUSTOMER APPROVAL VERIFICATION (YES/NO/NA)		10. CERTIFICATE OF CONFORMANCE NUMBER
4340 ALY STEEL .7500 X .800 X 2.3		AMS-6359		N/A	N/A		N/A
FOR ALTERNATE MATERIAL 4340 ALY STEEL SEE NOTE H		MIL-S-5000 OR AMS-6415		EMJ DALLAS 2030 W. COMMERCE ST. DALLAS, TX 75208-8025	N/A		HT # U6039
HEAT TREAT		BPS 4140		BODYCOTE 436849 2005 MONTGOMERY ST. FORT WORTH, TX 76107	YES		# 34-132644
CHECK HARDNESS		BPS 4467		FORE MACHINE CO. 41389 5912 EDEN DRIVE FORT WORTH, TEXAS 76117	YES		N/A
PHOSPHATE COATING		DOD-P-16232		BILLMARK CO. 2232 SOLONA ST HALTOM CITY, TX 76117	N/A		# 250381
MAGNETIC PARTICLE INSPECT		MIL-STD-1949 MIL-I-6868 BY ASTM-E-1444/ E1444M-16		AERO LABS AND METAL FINISHING 2513 MINNIS DR. FORT WORTH, TX 76117	N/A		# 104353
MARK PART		BPS 4050		FORE MACHINE CO. 41389 5912 EDEN DRIVE FORT WORTH, TEXAS 76117	N/A		N/A
PACKAGING AND PRESERVATION		BPS 4102		FORE MACHINE CO. 41389 5912 EDEN DRIVE FORT WORTH, TEXAS 76117	N/A		N/A
11. FUNCTIONAL TEST PROCEDURE NUMBER		12. ACCEPTANCE REPORT NUMBER, IF APPLICABLE					
13. COMMENTS:							
14. PREPARED BY: <i>C. Chase</i>		15. DATE: 11/30/2016					

JOB NO: 48945-0002

QTY: 1

QTY INSP: 1

SHEET 3 OF 4

1. PART NO:		B/P REV.	2. PART NAME:		3. SERIAL NO.		4. FAI RPT NO./REV	
T102146-105		C	CLIP		N/A		BSC	
5. CHAR NO.	6. REF. LOC.	7. CHAR DESIG.	8. REQUIREMENT	9. RESULTS	10. TOOLING INSP MEDIA	11. N.C. NUMBER	INSP STATUS	COMMENTS
1	F/D		.150 (± .010)	.150	TESA HITE		FORE 28 ACCP	
2	F/D		1.0 (± .1)	1.015	TESA HITE		FORE 28 ACCP	
3	F/D		.030 (± .010) R	.030 R	RADIUS GAGE		FORE 28 ACCP	
4	F/D		.10 (± .030) CHAMFER	.097	OPT COMP		FORE 28 ACCP	
5	F/D		45° (± 1/2°) CHAMFER	45	OPT COMP		FORE 28 ACCP	
6	F/D		.400 (± .010)	.406	TESA HITE		FORE 28 ACCP	
7	F/D		.150 (± .010)	.152-.155	TESA HITE		FORE 28 ACCP	
8	F/D		.030 (± .010) CHAMFER	.030	OPT COMP		FORE 28 ACCP	
9	F/D		45° (± 1/2°) CHAMFER	45	OPT COMP		FORE 28 ACCP	
10	F/D		.030 (± .010) CHAMFER 2PL	.033	OPT COMP		FORE 28 ACCP	
11	F/D		45° (± 1/2°) CHAMFER 2PL	45	OPT COMP		FORE 28 ACCP	
12	F/D		.200 (± .010)	.199-.200	TESA HITE		FORE 28 ACCP	
13	F/D		.300 (± .010) TYP	.300-.301	TESA HITE		FORE 28 ACCP	
14	F/D		.250-20 UNC-2B	ACCP T	THREAD GAGE		FORE 28 ACCP	
15	F/D		.2070-.1960 MINOR Ø	.202-.204	PINS		FORE 28 ACCP	
16	F/D		90° (± 1/2°) CSK BOTH SIDES	90	PROTRACTOR		FORE 28 ACCP	
17	F/D		.280 Ø (± .010) BOTH SIDES	.287	PINS		FORE 28 ACCP	
18	F/D		.224 - .218 Ø HOLE	.218-.219	PINS		FORE 28 ACCP	
19	F/D		⌀ E F ⌀ .014 M	.004	TESA HITE		FORE 28 ACCP	
20	F/D		.600 (± .010)	.603	TESA HITE		FORE 28 ACCP	

The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.

12. Prepared By: *Thamom Chaiy*

Master Check Sheet prepared by:

Date:

Revised By:

Date:

13. Date:

NOV 04 2016

JOB NO: 48945-0002

QTY: 1

QTY INSP: 1

SHEET 4 OF 4

1. PART NO:		B/P REV.	2. PART NAME:	3. SERIAL NO.	4. FAI RPT NO./REV			
T102146-105		C	CLIP	N/A	BSC			
5. CHAR NO.	6. REF. LOC.	7. CHAR DESIG.	8. REQUIREMENT	9. RESULTS	10. TOOLING INSP MEDIA	11. N.C. NUMBER	INSP STAMP	COMMENTS
21	F/D		1.875 (± .010)	1.878	TESA HITE		FORE 28 ACCP	
22	F/D		2.100 (± .010)	2.109	TESA HITE		FORE 28 ACCP	
23	F/D		MARK PART NO. "T102146-105" AND "PART OF -101 SET" ON BOTH HALVES PER BPS 4050 USING VIBRATING STYLUS.	ACCEPT	VISUAL		FORE 10 ACCP	
24	F/D		125 ✓ MACHINED SURFACES EXCEPT AS NOTED.	60 ✓	VISUAL		FORE 28 ACCP	
25	P/L		HEAT TREAT TO 145/165 KSI PER BPS 4140-E5.	ACCEPT	CERTS		FORE 10 ACCP	BCT # 34-13266 PO 54915
26	NOTE B		BREAK EDGES .015 R OR .015 X 40-50 DEGREES CHAMFER EXCEPT AS NOTED.	ACCEPT	VISUAL		FORE 10 ACCP	
27	NOTE C		RUNOUT OF ALL UNDESIGNATED SURFACES TO DATUM AXIS ESTABLISHED BY DATUMS -A & -B SHALL BE WITHIN .010 UNLESS OTHERWISE SPECIFIED.	.0015	NOTED		FORE 28 ACCP	
28	NOTE D		APPLY PHOSPHATE COATING PER DOD-P-16232 TYPE M, CLASS 2.	ACCEPT	CERTS		FORE 31 ACCP	55404 Billmark #250381
29	NOTE E		PRODUCT OF CARR LANE MFG. CO. 4200 CARR LANE COURT. ST. LOUIS, MISSOURI 63119.	ACCEPT	NOTED		FORE 10 ACCP	
30	NOTE F		CHECK HARDNESS ON INDICATED SURFACE ON RC SCALE PER BPS 4467 HARDNESS TO BE RC 32.0/37.0	RC 32.0- 32.5	ROCKWELL TESTER		FORE 28 ACCP	
31	NOTE G		MAGNETIC PARTICLE INSPECT PER MIL-STD-1949. ANY RATEABLE INCLUSION IS CAUSE FOR REJECTION. INCLUSIONS 1/8 INCH OR GREATER ARE RATEABLE.	ACCEPT	CERTS		FORE 10 ACCP	ALMF #104353 PO 55324
32	NOTE H		FOR ALTERNATE MATERIAL USE 4340 PER MIL-S-5000 OR AMS6415.	ACCEPT	NOTED		FORE 10 ACCP	
33	**		PACKAGING AND PRESERVATION PER BPS 4102.	ACCEPT	VISUAL		FORE 10 ACCP	

The signature indicates that all characteristics are accounted for, meet drawing requirements or are properly documented for disposition.

12. Prepared By: C. Chase

Master Check Sheet prepared by: ODD

Date: 10/11/2016

Revised By:

Date:

13. Date: 11/30/16

DALLAS

S.I.D. ORDER NO. T220142

ORDERED BY: GARY FORE

PHONE: 817 834-6251

CUST. ORD. NO.: 51095

FORE MACHINE CO

5912 EDEN DRIVE
FORT WORTH

TX 76117

S
H
I
P
T
O

FORE MACHINE CO

5912 EDEN DRIVE
HALTOM CITY

TX 76117

FAX: 817 8389111

001

XFER # 00423

PAGE 1 OF 1
ROBERT 1242015
B500809

T 243526

DATE ORD.		CUSTOMER P.O.		F.O.B.	DEL AREA	VIA	CUST. ACCT.	PROM. DATE
16-NOV-18		51095		DESTIN	12-4R0B	OUR TRUCK	127339	04-DEC-15
ORDER WGT.	I/S	TERR.	TYPE	TAX RATE	PPD/COLL	C.O.D.	TEST REPORT	SHIP DATE
217	WESLEY GIPSON		CT		PREPAID	2	0 PRO #	Y 03-DEC-15

*** To be INDIRECT SHIPPED from Branch 00423

508745 E4340 HR ANN AQ PLATE DESC & OILED AMS 6359
3.00 EA 5/8 S/C 8.500" X 48.000" RECTANGLE 216.9000 LB
ALM W/FT 25.5200 EXT WGT:
PT#508745 JOB/BTCH# 51095

217
PO LN#

1 12000000 00000000 00000000 00000000 00000000 00000000 00000000 00000000

Best Effort
CUTTING PLATE SAW
Processing Tolerance: +1/4 -0
CUT 3 PCS @ 8.500" X 48.000"
U6039 LOCATION: TRANSFER

1 BND
238 LB

3 PC

These commodities are controlled for export by the United States government under the Export Administration Regulations. Diversion contrary to U.S. law is prohibited. Purchaser is responsible to comply with these regulations if the items are to be exported from the United States or re-exported from a foreign country. See <http://www.bis.doc.gov> for U.S. requirements. ECCN# EAR99 License# _____

[illegible]

RECEIVED ABOVE GOODS IN TERMS AND CONDITIONS APPEARING ON BACK OF INVOICE					X		INVOICE AMT.		ADDITIONAL CHARGES		V.A.T. TAX		TAX/AMT.		TOTAL		
NO. OF PKGS.	PKG. TYPE	NO. OF PKGS.	PKG. TYPE	TOTAL PCS.	DESCRIPTION OF ARTICLES			SHIP WGT.	CLS	FREIGHT CHARGES ARE TO BE PRE- PAID UNLESS THIS BLOCK IS CHECKED ☐			Subject to Section 7 of conditions, if the consignee is to be delivered to the consignee without success on the consignee, the consignee shall sign the following statement: The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges. (Signature of Consignee)			C.O.D. AMOUNT	
1	Ttl				1 IRN/STL PLATE SHEET			106	217	050							
											CARRIER SEND FREIGHT BILL TO:			C.O.D. FEE TO BE PAID BY			
														SHIPPER ☐ CONSIGNEE ☐			
														CARRIER			
														AGENT			
														PER:			
PACKING SLIP				1	TOTAL				217		SHIPPER PER X						

Customer: FORE MACHINE CO

Ord #: T220142 Part #: 508745 Cust PO#: 51095

SHIP TO: ARCELORMITTAL PLATE LLC
EARLE M. JORGENSEN CO.
1900 MITCHELL BLVD BAY 1
SCHAUMBURG IL 60193

TEST CERTIFICATE

PAGE NO: 01 OF 02
FILE NO: 4101-07-07
MILL ORDER NO: 52833-001
MELT NO: U6039
SLAB NO: 3AA
DATE: 11/16/15

SOLD TO: EARLE M. JORGENSEN CO.
1900 MITCHELL BLVD BAY 1
SCHAUMBURG IL 60193

SEND TO:

01-C

R7679++

STEEL PLATE DIMENSIONS / DESCRIPTION

TOTAL QTY	GAUGE	WIDTH	LENGTH	DESCRIPTION	PIECE WEIGHT
2	.625"	96"	240"	RECTANGLE	4084#

CUSTOMER INFORMATION

CUSTOMER PO: P678506-423

PART NO. 508745

SPECIFICATION (S)

THIS MATERIAL HAS BEEN MANUFACTURED AND TESTED IN ACCORDANCE WITH PURCHASE ORDER REQUIREMENTS AND SPECIFICATION(S).

AMS 6359J YR 11 AIRCRAFT
AIRCRAFT QUALITY AISI E4340 97 AND AMS 2252
AMS 2301 REV. K

THE MANAGEMENT SYSTEMS FOR MANUFACTURE OF THIS PRODUCT ARE CERTIFIED TO ISO 9001:2008 (CERTIFICATE NO. 30130) AND ISO 14001:2004 (CERTIFICATE NO. 49009).

CHEMICAL COMPOSITION (WT%) FOR ALL ELEMENTS EXCEPT H (PPM)

	C	MN	P	S	CU	SI	NI	CR	MO
MELT:U6039	.41	.73	.012	.002	.15	.24	1.73	.75	.24
PROD ANALYSIS	.43	.71	.012	.003	.15	.25	1.74	.74	.24
	V	AL	CB						
MELT:U6039	.044	.006	.004						
PROD ANALYSIS	.041	.006	.003						

JOMINY TESTING

	1	2	3	4	6	8	12	16	20	24	32
MELT	57	56	56	55	55	55	55	55	53	53	52

MANUFACTURE

ELECTRIC FURNACE QUALITY - FINELINE - VACUUM DEGASSED - FINE GRAIN
PRACTICE - MCQUAID-EHN GRAIN SIZE PER E112 - 7-8

WE HEREBY CERTIFY THE ABOVE
INFORMATION IS CORRECT:

ARCELORMITTAL PLATE LLC
QUALITY ASSURANCE LABORATORY
139 MODENA ROAD
COATESVILLE, PA 19320

Elinore Zaplitny
SUPERVISOR - TEST REPORTING
ELINORE ZAPLITNY

TEST CERTIFICATE

PAGE NO: 02 OF 02
FILE NO: 4101-07-07
MILL ORDER NO: 52833-001
MELT NO: U6039
SLAB NO: 3AA
DATE: 11/16/15

HEAT TREAT CONDITION

MATL OR TEST	HEAT TREAT DESCRIPTION	NOM TEMP	HOLD MINS	COOL MTHD	START END TEMP
PL/TEST	ANNEAL	1475F	301	FURN.COOL	1300F
PL/TEST	ANNEAL	1300F	300	FURN.COOL	1000F

MECHANICAL PROPERTIES

SLAB - 3AA - BRINELL PER E110 (HBW) - 241 - PLATE

BEND TEST - BOT./TRANS. - PASS

BEND TEST - TOP/TRANS. - PASS

DECARB TESTING - METALLOGRAPHIC METHOD

LOC	DEPTH IN INCHES
BOT.	.012
BOT.	.010
TOP	.014
TOP	.015

OTHER METALLURGICAL AND MICROSTRUCTURAL TESTS

MAGNETIC PARTICLE - FREQUENCY .00001 - SEVERITY .00001

GENERAL INFORMATION

ALL STEEL HAS BEEN MELTED AND MANUFACTURED IN THE U.S.A.
MATERIAL HAS BEEN VACUUM DEGASSED AND CALCIUM TREATED
FOR SULFIDE SHAPE CONTROL.
FINELINE MOD FOR SULPHUR
BRINELL TESTING WAS PERFORMED USING A CARBIDE BALL (HBW).
MAG.PART.FREQ. AND SEVERITY RATING PER AMS-2301K.
ACID SOLUBLE ALUMINUM
FOR MORE INFORMATION AND PROCESSING GUIDELINES, REFER TO
WWW.USA.ARCELORMITTAL.COM/PLATE

B/L #87332 EMJ LOGISTICS

WE HEREBY CERTIFY THE ABOVE
INFORMATION IS CORRECT:

ARCELORMITTAL PLATE LLC
QUALITY ASSURANCE LABORATORY
139 MODENA ROAD
COATESVILLE, PA 19320

Elinore Zaplitny
SUPERVISOR - TEST REPORTING
ELINORE ZAPLITNY



2005 MONTGOMERY STREET - FORT WORTH, TEXAS 76107-4012
TEL: 817-737-6651 METRO: 817-429-2248 FAX: 817-737-2221

Cert No. 34-132644
Certified: 10/24/2016

Bill To

Ship To

Fore Machine
5933 Eden Street
Fort Worth, TX 76117

Ship To: 34-28830-1
Fore Machine
5933 Eden Street
Fort Worth, TX 76117

CERTIFICATION

Order No 163383	PO Number 54915	PL Number	Received 10/11/2016 5:13:51 PM
Requirements			Value
Surface Hardness Min (HRC)			32.0
Surface Hardness Max (HRC)			37.0
Qty 63	Wgt 20.16	Part No. T102146-105	Part Name Clip Job:48945-0002 Bell PO:4500919128
Part Description Heat Treat to 145-165 KSI			Material 4340
63	20.16	Total	

We hereby certify that the parts described above were given the following Heat Treatment and that the temperatures and test results were obtained with standard approved methods.

Order has been processed in accordance with all requirements of purchase order instructions.

Recorded Values	Readings
Surface Hardness Min (HRC)	32.3
Surface Hardness Max (HRC)	33.7
Quantity Inspected = (integer)	13

Processed per BPS4140G
Hardness Tested per BPS4467C

Fce#73 - Preheated @ 1000°F for 1 Hour
Fce#74 - Endo Hardened @ 1500°F for 1.25 Hour - Oil Quenched
Fce#73 - Tempered @ 1075°F for 4 Hours - Air Cooled
Fce#69 - Re-tempered @ 1110°F for 4 Hours - Air Cooled

All processes involved in the production of these articles and requiring specific process approval have been so approved and certificates are on file subject to examination.

All parts were tested in accordance with ASTM E10-15a, ASTM E18-16, ASTM E384-16, and ASTM A956-12, ASTM E-1004-09 as applicable.

Bodycote Thermal Processing - Fort Worth, Texas
NADCAP Certificate#3519165831
AS9100C Certificate#13017ASR001
Certified: 10/24/2016
By: Erica Gill Customer Service Rep

Erica Gill

AERO LABS & METAL FINISHING

2513 MINNIS DR
FORT WORTH, TEXAS 76117
(682) 647-1616
(682) 647-1311 FAX

CERTIFICATION
MAGNETIC PARTICLE
INSPECTION

CUSTOMER: FORE MACHINE P. O. # 55324

PRIME: CUSTOMER PO #45009191 ALMF JOB #: 104353

QUANTITY: 62 ALMF PROCEDURE # 200F

PART NUMBER: T102146-105, JOB #: 48945-0002

PART NAME: CLIP

MATERIAL: 4340 ALLOY STEEL, 145-165 KSI

INSPECTED PER: MIL-I-6868 SUPERSEDED BY ASTM-E-1444/E1444M-16

ACCEPTANCE CRITERIA: MIL-STD-1907, GRADE C

AREA EXAMINED: 100%

TECHNIQUE REFERENCE: N/A

EQUIPMENT: MAGNAFLUX WET HORIZONTAL UNIT. MODEL ARQ-966 WITH AUTOMATIC A.C.
DEMAGNETIZATION, 20" I.D. 5 TURN COIL FULL WAVE DIRECT CURRENT. SYSTEM
PERFORMANCES VERIFIED BY THE KETOS RING TEST. SYSTEM CALIBRATED SEMI
ANNUALLY AND SET FOR .5 SECOND SHOT DURATION.

SOLUTION: MAGNAFLUX 14A FLOURESCENT PARTICLES AND MX-MG CARRIER II.
PARTICLE CONCENTRATION .16 ml

INSPECTION RESULTS: QUANTITY ACCEPTED 62
QUANTITY REJECTED 0

COMMENTS:

THIS DOCUMENT CERTIFIES THAT THE ABOVE PARTS HAVE BEEN PROCESSED IN ACCORDANCE WITH THE LISTED
SPECIFICATIONS. ALL APPLICABLE TECHNIQUES AND RECORDS ARE ON FILE AND AVAILABLE FOR REVIEW.

APPROVED BY: Larry Pond LEVEL II DATE: 11/15/2016

LARRY POND



EVIDENCE OF CONFORMANCE (Process)

I CERTIFY THAT THE QUANTITIES AND PARTS LISTED BELOW FOR

Fore Machine Co Inc

SHIPPED ON P.O. NO.

55404

OUR DELIVERY TICKET

250381

HAVE BEEN

Phosphate Plated

PER SPECIFICATION

MIL-DTL-16232G Ty.M Cl.2

AS ORDERED.

Quantity

Part Number/Description

62 T102146-105 Job: 48945-0002

62 Total Parts for this Job

Job: 11232016-8

No tests.

THE APPROPRIATE EVIDENCE OF PROPER MATERIALS, TESTS AND PROCESS CONTROL USED ON THE PLATING OF THE ABOVE PARTS IS IN OUR FILE FOR INSPECTION BY THE PURCHASING CONTRACTOR. WE HEREBY CERTIFY THAT THE PARTS LISTED ABOVE WERE PROCESSED TO THE ABOVE SPECIFICATIONS AND ARE NOT LIABLE FOR ANY MISLEADING INFORMATION GIVEN BY THE PURCHASING CONTRACTOR OR ANY PURCHASE ORDER.

BILLMARK COMPANY, INC.



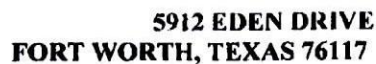
BY:

Mark Shafer
Mark Shafer, President

2232 Solona Street
Fort Worth, Texas 76117
817-429-5356
817-834-2480 FAX

Date:

23-Nov-16



- ☐ FINAL CHECK SHEET
☐ CONFORMITY CHECK SHEET
☒ FIRST ARTICLE CHECK SHEET

SAE AS9102 Form 1: Part Number Accountability

SHEET 1 OF 6

CUSTOMER: FORE			ODS / MEPI: N/A		PHY CHG: N/C		QTY. 1SET		MFG. DATE: 10/19/2016		
1. PART NO: T102146-103			2. PART NAME: PLATE SET			3. SERIAL NO. FN308			4. FAI RPT NO. /REV. BSC		
5. PART REV. -		6. DWG: T102146		7. B/P REV: C P/L REV: B		8. CHANGE/E.O. N/C			9. MFG. PROCESS REF. (JOB #) 48755-0001		
10. ORG. NAME FORE MACHINE CO.		11. SUPPLIER CODE N/A		12. P.O. NUMBER STOCK		13. DETAIL FAI ☐ ASSY FAI ☒		14. FULL FAI ☒ PARTIAL FAI ☐		Baseline Part Number and rev.: Reason For Partial FAI:	
INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.											
15. PART NUMBER		16. PART NAME		17. PART SERIAL NUMBER							
T102146-107 (1EA)		PLATE HALF									
T102146-109 (1EA)		PLATE HALF									
						☐ Controlled Item ☐ 1-Primary ☐ 2-Primary Traceable ☒ Non Controlled ☐ 3-Critical ☐ 4-Makes a Critical ☐ 5-Flight Safety ☐ 6-Fatigue Controlled					
						Customer Approval: _____ Date: _____					
						1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.					
						2) Also indicate if the FAI is complete per Section 5.4:					
						☒ FAI COMPLETE ☐ FAI NOT COMPLETE					
						19. SIGNATURE CRISTINA CRUSE 					
						20. DATE 10/19/2016					

1. PART NO: T102146-103		B/P REV. C	2. PART NAME: PLATE SET		3. SERIAL NO. FN308		4. FAI RPT NO./REV BSC	
5. MATERIAL OR PROCESS NAME		6. SPECIFICATION NUMBER		7. CODE	8. SPECIAL PROCESS SUPPLIER CODE	9. CUSTOMER APPROVAL VERIFICATION (YES/NO/NA)		10. CERTIFICATE OF CONFORMANCE NUMBER
4340 ALY STEEL .7500 X 4.0 X 4.0		AMS-6359			EM JORGENSEN 2030 W. COMMERCE ST DALLAS, TX 75208	N/A		IIT# D58906L
FOR ALTERNATE MATERIAL 4340 ALY STEEL SEE NOTE H		MIL-S-5000 OR AMS-6415			N/A	N/A		N/A
HEAT TREAT		BPS 4140			BODYCOTE 436849 2005 MONTGOMERY ST. FORT WORTH, TX 76107	YES		# 34-131747
CHECK HARDNESS		BPS 4467			FORE MACHINE CO. 41389 5912 EDEN DRIVE FORT WORTH, TEXAS 76117	YES		N/A
PHOSPHATE COATING		DOD-P-16232			BILLMARK CO. 2232 SOLONA ST HALTOM CITY, TX 76117	N/A		#250006
MAGNETIC PARTICLE INSPECT		MIL-STD-1949			AAXON LABS, INC. 458759 4113 MURRAY AVE. FORT WORTH, TX 76117	N/A		#90224
MARK PART		BPS 4050			FORE MACHINE CO. 41389 5912 EDEN DRIVE FORT WORTH, TEXAS 76117	N/A		N/A
PACKAGING AND PRESERVATION		BPS 4102			FORE MACHINE CO. 41389 5912 EDEN DRIVE FORT WORTH, TEXAS 76117	N/A		N/A
11. FUNCTIONAL TEST PROCEDURE NUMBER		12. ACCEPTANCE REPORT NUMBER, IF APPLICABLE						
13. COMMENTS:								
14. PREPARED BY: <i>C. Cruise</i>		15. DATE: 10/19/2016						

1. PART NO:		B/P REV.	2. PART NAME:		3. SERIAL NO.		4. FAI RPT NO./REV	
T102146-103		C	PLATE SET		FN308		BSC	
5. CHAR NO.	6. REF. LOC.	7. CHAR DESIG.	8. REQUIREMENT	9. RESULTS	10. TOOLING INSP MEDIA	11. N.C. NUMBER	INSP STAMP	COMMENTS
1	F/D		.750 (± .010) 2PL	.752	TESA HITE		FORE 28 ACCP	T102146-107
2	F/D		1.855 (± .010) TYP	1.857	TESA HITE		FORE 28 ACCP	T102146-107
3	F/D		1.630	1.630	TESA HITE		FORE 28 ACCP	T102146-107 DEVIATION: .0015
4	F/D		.020 (± .010) R TYP 4 PLS	.020 R	RADIUS GAGE		FORE 28 ACCP	T102146-107
5	F/D		.327 - .334 Ø 2PL	.328	PINS		FORE 28 ACCP	T102146-107
6	F/D		.50 (± .030) DEEP 2PL	.502	CALIPERS		FORE 28 ACCP	T102146-107
7	F/D		.3125 - .3130 Ø 2PL	.3125-.312	AIR GAGE		FORE 28 ACCP	T102146-107
8	F/D		1.10 (± .030) DEEP 2PL	1.099	CALIPERS		FORE 28 ACCP	T102146-107
8A	**		.196 - .207 MINOR Ø	.197	PINS		FORE 28 ACCP	T102146-107
9	F/D		.250-20 UNC-2B	Accept	THREAD GAGE		FORE 28 ACCP	T102146-107
10	F/D		.625 Ø (± .010) S'FACE 2PL	.625	CALIPERS		FORE 28 ACCP	T102146-107
11	F/D		.030 (± .010) FIL R	.030 R	RADIUS GAGE		FORE 28 ACCP	T102146-107
12	F/D		⊕ A ⊗ B C Ø .014 ⊗	.010	TESA HITE		FORE 37 ACCP	T102146-107
13	F/D		.057 - .067 TYP	.063	TESA HITE		FORE 28 ACCP	T102146-107
14	F/D		.115 - .135 TYP	.126	TESA HITE		FORE 28 ACCP	T102146-109
15	F/D		15° (± 1/2°) TYP	15°	PROTRACTOR		FORE 28 ACCP	T102146-109
16	F/D		.625 - .635 SLOT 2PL	.630	TESA HITE		FORE 28 ACCP	T102146-109
17	F/D		⊕ A ⊗ B C Ø .014 ⊗ 2PL	.0035	TESA HITE		FORE 37 ACCP	T102146-109
18	F/D		.190-32 UNC-2B	Accept	THREAD GAGE		FORE 28 ACCP	T102146-109
18A	**		.1560 - .1641 MINOR Ø	.1565	PINS		FORE 28 ACCP	T102146-109

The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.

12. Prepared By: THANOM CHAY P 13. Date: SEP 29 2016

Master Check Sheet prepared by: _____ Date: _____ Revised By: _____ Date: _____

1. PART NO:		B/P REV.	2. PART NAME:		3. SERIAL NO.		4. FAI RPT NO./REV	
T102146-103		C	PLATE SET		FN308		BSC	
5. CHAR NO.	6. REF. LOC.	7. CHAR DESIG.	8. REQUIREMENT	9. RESULTS	10. TOOLING INSP MEDIA	11. N.C. NUMBER	INSP STAMP	COMMENTS
19	F/D		.218 - .224 Ø C'DRILL 2PL	.220	PINS		FORE 28 ACCP	T102146-109
20	F/D		.250 (± .010) C'DRILL DEEP 2PL	.251	CALIPERS		FORE 28 ACCP	T102146-109
21	F/D		Φ A B D M Ø .014 M 2PL	.0035	TESA HITE		FORE 28 ACCP	T102146-109
22	F/D		.500 (± .010) R 2PL	.500 R	RADIUS GAGE		FORE 28 ACCP	T102146-109
23	F/D		1.13 (± .030) 2PL	1.130	TESA HITE		FORE 37 ACCP	T102146-109 / T10146-107
24	F/D		.200 (± .010) TYP	.201	TESA HITE		FORE 28 ACCP	T102146-109 / T10146-107
25	F/D		.030 (± .010) R TYP	.030 R	RADIUS GAGE		FORE 28 ACCP	T102146-109 / T10146-107
26	F/D		.38 (± .030) TYP	.380	TESA HITE		FORE 28 ACCP	T102146-109 / T10146-107
27	F/D		.19 (± .030) TYP	.190	TESA HITE		FORE 28 ACCP	T102146-109 / T10146-107
28	F/D		.425	.425	TESA HITE		FORE 37 ACCP	T102146-109 / T10146-107 DEVIATION: .001
29	F/D		.650 (± .010)	.652	TESA HITE		FORE 28 ACCP	T102146-109 / T10146-107
30	F/D		.200 (± .010)	.203	TESA HITE		FORE 28 ACCP	T102146-109 / T10146-107
31	F/D		∠ A B .005	.002	INDICATOR		FORE 37 ACCP	T102146-109 / T10146-107
32	F/D		1.800 - 1.805 Ø	1.8015	DIAL BORE		FORE 37 ACCP	T102146-109 / T10146-107
33	F/D		63 ✓	35 ✓	PROFILOMETER		FORE 28 ACCP	T102146-109 / T10146-107
34	F/D		⊥ A B .005	.0015	INDICATOR		FORE 37 ACCP	T102146-109 / T10146-107
35	F/D		2.670 - 2.675 Ø	2.672	O.D. MIC		FORE 28 ACCP	T102146-109 / T10146-107
36	F/D		.006 MAX EDGE BREAK		VISUAL		FORE 37 ACCP	T102146-109 / T10146-107
37	F/D		.030 (± .010) R	.030 R	RADIUS GAGE		FORE 28 ACCP	T102146-109 / T10146-107
38	F/D		□ .002	.001	INDICATOR		FORE 28 ACCP	T102146-109 / T10146-107

The signature indicates that all characteristics are accounted for, meet drawing requirements or are properly documented for disposition.

12. Prepared By: THANOM CHAY P Date: _____ Revised By: _____ Date: _____

Master Check Sheet prepared by: _____

13. Date: SEP 29 2016

1. PART NO:		B/P REV.	2. PART NAME:		3. SERIAL NO.		4. FAI RPT NO/REV	
T102146-103		C	PLATE SET		FN308		BSC	
5. CHAR NO.	6. REF. LOC.	7. CHAR DESIG.	8. REQUIREMENT	9. RESULTS	10. TOOLING INSP MEDIA	11. N.C. NUMBER	INSP STAMP	COMMENTS
39	F/D		63 ✓	24 ✓	PROFILOMETER		FORE 28 ACCP	T102146-109 / T10146-107
40	F/D		.425 2PL	.425	TESA HITE		FORE 37 ACCP	T102146-109 / T10146-107 DEVIATION: .005
41	F/D		3.40 Ø (± .030)	3.398	O.D. MIC		FORE 28 ACCP	T102146-109 / T10146-107
42	F/D		1.530 (± .010) TYP	1.525-1.526	TESA HITE		FORE 37 ACCP	T102146-109 / T10146-107
43	F/D		60°	60	TESA HITE		FORE 37 ACCP	T102146-109 / T10146-107 DEVIATION:
44	F/D		.25 (± .030) TYP	.255	TESA HITE		FORE 28 ACCP	T102146-109 / T10146-107
45	F/D		125 ✓ MACHINED SURFACES EXCEPT AS NOTED.	60 ✓	VISUAL		FORE 28 ACCP	T102146-109 / T10146-107
46	F/D		MARK PART NO. "T102146-103" AND "PART OF -101 SET" ON BOTH HALVES PER BPS 4050 USING VIBRATING STYLUS.	ACCEPT	VISUAL		FORE 10 ACCP	
47	NOTE A		MUST BE STOCKED AS -103 MATCHED SET.	ACCEPT	NOTED		FORE 10 ACCP	
48	NOTE B		BREAK EDGES .015 R OR .015 X 40-50 DEGREES CHAMFER EXCEPT AS NOTED.	.015 R	VISUAL		FORE 28 ACCP	
49	NOTE C		RUNOUT OF ALL UNDESIGNATED SURFACES TO DATUM AXIS ESTABLISHED BY DATUMS -A & -B SHALL BE WITHIN .010 UNLESS OTHERWISE SPECIFIED.	.001	NOTED		FORE 28 ACCP	
50	NOTE D		APPLY PHOSPHATE COATING PER DOD-P-16232 TYPE M, CLASS 2.	ACCEPT	CERTS		FORE 16 ACCP	54847
51	NOTE E		PRODUCT OF CARR LANE MFG. CO. 4200 CARR LANE COURT. ST. LOUIS, MISSOURI 63119.	ACCEPT	NOTED		FORE 10 ACCP	
52	NOTE F		CHECK HARDNESS ON INDICATED SURFACE ON RC SCALE PER BPS 4467 HARDNESS TO BE RC 32.0/37.0	RC=32.0 32.5	ROCKWELL TESTER		FORE 28 ACCP	

The signature indicates that all characteristics are accounted for, meet drawing requirements or are properly documented for disposition.

12. Prepared By:

C. Cruise

13. Date:

10/19/16

Master Check Sheet prepared by:

Date:

Revised By:

Date:

12. Prepared By: <u>E. Cause</u>				13. Date: 10/19/2016	
Master Check Sheet prepared by: ODD		Date: 08/25/2016	Revised By:		Date:

FROM: EARLE M. JORGENSEN COMPANY
2030 WEST COMMERCE STREET
DALLAS

S.I.D. ORDER NO. T244313
ORDERED BY: GARY FORE
PHONE: 817 834-6251
CUST. ORD. NO.: 53987

S
O
L
D

FORE MACHINE CO

5912 EDEN DRIVE
FORT WORTH

TX 76117

S
H
I
P

FORE MACHINE CO

5912 EDEN DRIVE
HALTOM CITY

TX 76117

FAX: 817 8389111
009

PAGE 1 OF 1
ROBERT 892016
B006749

REF # 00423

T510454

DATE ORD.		CUSTOMER P.O.		F.O.B.		DEL AREA		VIA		CUST. ACCT.		PROM. DATE	
27-JUL-16		53987		DESTIN		8-9ROB		OUR TRUCK		127339		09-AUG-16	
ORDER WGT.		HS		TERR.		TYPE		TAX RATE		PPD/COLL		C.O.D.	
133		WESLEY GIPSON		CT				PREPAID		2		0	
								TEST REPORT		PRO #		SHIP DATE	
										Y		08-AUG-16	

*** To be INDIRECT SHIPPED from Branch 00423

508746 E4340 HR ANN AQ PLATE DESC & OILED AMS 6359
1.00 EA 3/4 S/C 13.000" X 48.000" RECTANGLE 132.7255 LB
ALM W/FT 30.6300 EXT WGT: 133
PT#508746 JOB/BTCH# 53987 PO LN#



Best Effort
CUTTING PLATE SAW

Processing Tolerance: +1/4 -0
CUT 1 PCS @ 13.000" X 48.000"

HEAT # D58906L

1 PCS
133 LB

1 PC

AUG 15 2016



48755-0001
T1021426103

These commodities are controlled for export by the United States government under the Export Administration Regulations. Diversion contrary to U.S. law prohibited. Purchaser is responsible to comply with these regulations if the items are to be exported from the United States or re-exported from a foreign country. See <http://www.bis.doc.gov> for U.S. requirements. ECCN# EAR99 License#

The property described below in apparent good order except as noted (contents and condition of contents unknown) marked, consigned and destined as indicated below, which said carrier, (the word carrier being understood throughout this contract as meaning any person or corporation in possession of the property under the contract) agreed to carry to its usual place of delivery at said destination if on its route, otherwise to deliver to another carrier on the route to said destination if it is mutually agreed as to each carrier of all or any of said property over all or any portion of said route to destination and as to each party at any time interested in all or any of said property that every service to be performed hereunder shall be subject to all terms and conditions of the Uniform Domestic Straight Bill of Lading set forth (1) in Official, Southern, Western, and Illinois Freight Classification in effect on the date hereof, if this is a rail or rail water shipment, or (2) in the applicable motor carrier classification or tariff if this is a motor carrier shipment. Shipper hereby certifies that he is familiar with all the terms and conditions of the said bill of lading, including those on the back thereof, set forth in the classification or tariff which govern the transportation of this shipment and the said terms and conditions are hereby agreed to by the shipper and accepted for himself and his assigns.

CEIVED ABOVE GOODS TERMS AND CONDITIONS PEARING ON BACK OF INVOICE					INVOICE AMT.		ADDITIONAL CHARGES		V.A.T. TAX		TAX/AMT.		TOTAL						
X																			
NO. OF PKGS.					DESCRIPTION OF ARTICLES					SHIP WGT.		CLS		FREIGHT CHARGES ARE TO BE PAID UNLESS THIS BLOCK IS CHECKED		C.O.D. AMOUNT			
PKG. TYPE														Subject to Section 7 of conditions, if this shipment is to be delivered to the consignee without recourse to the consignee, the consignee shall sign the following statement. The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges. Signature of Consignee					
1					1 IRN/STL PLATE SHEET					106		133		050		CARRIER SEND FREIGHT BILL TO:		C.O.D. FEE TO BE PAID BY	
																SHIPPER ☐ CONSIGNEE ☐			
																CARRIER			
																AGENT			
																PER			
PACKING SLIP					TOTAL					133				SHIPPER PER X					

JOYGLOBAL

JOY GLOBAL LONGVIEW OPERATIONS LLC
LONGVIEW, TEXAS, U.S.A.
ISO 9001:2008 Registered Quality System
Material Test Report

R 891517

REPORT OF CHEMICAL AND PHYSICAL TESTS OF STEEL PLATE

DATE: 05/12/16

PAGE: 1 of 1

SOLD TO: Earle M. Jorgensen - Schaumburg
1900 Mitchell Blvd.
Schaumburg IL 60193

SALES ORDER NO.: 196930
PURCHASE ORDER NO.: P723621-423

GRADE: AMS6359K, Annealed

SIZE: 0.75" x 96" x 260"

HEAT NO.: D58906L ROLL NO.: 92521

CUSTOMER PRODUCT: 508746

LADLE ANALYSIS

C	MN	S	P	SI	CR	NI	MO	AL	V	CU	NB
0.4300	0.7200	0.0041	0.0060	0.2680	0.8400	1.7900	0.2600	0.0240	0.0050	0.2170	0.0021

PHYSICAL ANALYSIS

HEAT	TIME	YIELD STRENGTH	TENSILE STRENGTH	2" GAGE	HARDNESS	CHARPY TEST INFO			
TREAT TEMP	HRS/MINS	(psi)	(psi)	%ELONG	LOW/HIGH	TEMP	TYPE	FT/LBS	% SHEAR
Annealed									
1500F	34:15				229 - 229 BHN				

Depth of decarburization (metallographic method): 0.011"

ELECTRIC FURNACE MELTED.

ASTM A829 GRADE 4340, 2014 EDITION. AIRCRAFT QUALITY AMS6359K. CLEANLINESS AMS2301K. CAST JOMINY. REDUCTION RATIO 21.3:0
FREQUENCY-SEVERITY 0.59/0.65 VACUUM DEGASSED; CALCIUM TREATED FOR INCLUSION SHAPE CONTROL. MATERIAL TEST REPORT
PREPARED IN ACCORDANCE WITH EN 10204 3.1, 2004 REV.

MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.

IN ACCORDANCE WITH THE RECORDS OF JOY GLOBAL LONGVIEW OPERATIONS LLC, I CERTIFY THE ABOVE INFORMATION IS CORRECT.

Anna Bowers

ANNA BOWERS

TECHNICAL SERVICES DEPARTMENT

JOYGLOBAL**MAGNETIC PARTICLE INSPECTION REPORT**

Inspector: Richard Mills

Date: 5/9/16

Inspector Badge No.: 159109

Certification Level: 2

Customer: Stock

Serial Number: N/A

Item Description: 2301-K Sample

Plate No.: 92521

Item MO: 103862208

Heat No.: D58906L

Item Drawing Number: N/A

Material Spec.: AMS6359K

Inspection Procedure: ☒ LTI Procedure 0300.43☐ Other**SPECIFICATIONS/STANDARDS**☐ AWS D1.1☐ AWS D14.3☐ AWS D14.4☐ ASME Section VIII☐ DNV☐ ABS☐ Specified by Drawing☒ Other AMS 2301-K**PROCESS RECORD**Test Method: ☒ A.C. ☐ D.C. Horizontal Bench☐ A.C. Yoke ☐ D.C. Yoke

Equipment Manufacturer/Model: Magnaflux/AD945L

Serial Number: 90461

Surface Preparation☐ Wire Brushing☐ Chipping ☐ Gouging☐ Grinding☐ Brushing/Scraping☒ Other Mechanical Cleaning**Application:**

Lift Test NA lbs.

Date of Calibration/Test: 8/22/15

Current 800-1200

Prod Spacing inches: N/A

A/in. Dia.

Pole Spacing N/A inches

☐ Single Pole (axial field)

Pie Gauge Check:

☒ Acceptable ☐ Unacceptable

Magnetizing Technique:

☒ Continuous ☐ Residual**Magnetic Particle Media:**☐ Visible Dry Particles

Particle Color:

☐ Fluorescent Dry Particles☐ Visible Wet Particles

Particle Color: YELLOW / GREEN

☒ Fluorescent Wet Particles

Particle Brand: MAGNAFLUX

Particle Size: 14 AM

Particle Concentration: 0.1 - 0.4 mL per 100 mL of Solution

Particle Vehicle: Carrier II

Particle Solution Age: hours

Inspection:Black Light Intensity: 1000 microwatts/cm² @ 15 inches

White Light Intensity: <2 foot candles @ test surface

Length of Weld Examined: N/A

TEST RESULTS

Acceptance Status

☒ Accept☐ Reject☐ Associated CAR

Joy Global Inspector: Richard Mills

Date: 5/9/16

JOYGLOBAL**MAGNETIC PARTICLE INSPECTION REPORT**

Inspector: Richard Mills

Date: 5/9/16

Inspector Badge No. 159109

Certification Level: 2

Customer: Stock

Serial Number: N/A

Item Description: 2301-K Sample

Plate No.: 92521

Item MO: 103862208

Heat No.: D58906L

Item Drawing Number: N/A

Material Spec.: AMS6359K

Inspection Procedure: ☒ LeT Procedure 0300.43☐ Other**INDICATION RECORD**

Part or Weld Number	Indication Type*		Repair		Remarks
	Accept	Reject	Accept	Reject	
2301-K Sample	☒	☐	☐	☐	Average Frequency Rating: 0.59
	☐	☐	☐	☐	Average Severity Rating: 0.65
	☐	☐	☐	☐	
	☐	☐	☐	☐	
	☐	☐	☐	☐	
	☐	☐	☐	☐	
	☐	☐	☐	☐	
	☐	☐	☐	☐	
	☐	☐	☐	☐	

Weld Map Notes:

WPS:

Accredited
ISO 9001 / 17025

L.L.P. P.O. Box 802404 ♦ Houston, TX 77280-2404 ♦ Telephone (713) 460-3655 ♦ Fax (713) 460-3695

Report Date: 4/14/2016

Report No: 747852.00

Rev.: A

Cust Acct: JOY606

To: Joy Global, Inc.
P O Box 2307
Longview, TX 75806

Ordered By: Anna Bowers

PO#: 4300000835

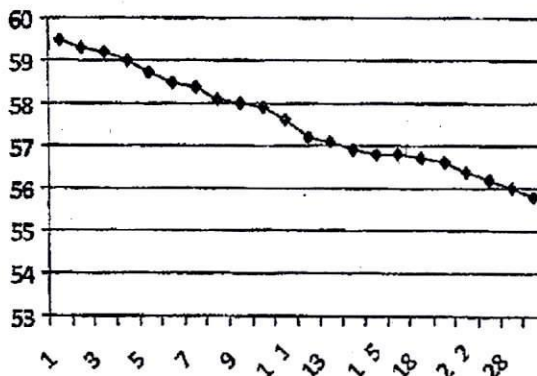
Material: AMS6359K Cast Jominy 1"OD X 9"Long Test Pc

ID/Heat: D58906L Jominy

Job Info: AMS6359K

Jominy End-Quench Test Report

Location	Hardness	Location	Hardness
1	59.5	12	57.2
2	59.3	13	57.1
3	59.2	14	56.9
4	59.0	15	56.8
5	58.7	16	56.8
6	58.5	18	56.7
7	58.4	20	56.6
8	58.1	22	56.4
9	58.0	24	56.2
10	57.9	28	56.0
11	57.6	32	55.8

Note: Locations are in 1/16" increments &
hardness readings are in Rockwell "C"**Comments/ Test Notes**Normalize at 1,600°F for 1 hour, air cool.
Austenitize at 1,550°F for 30 minutes.

Document

Reviewed By:

Yvonne Arredondo
Yvonne Arredondo
Documentation Specialist

Our reports are for the exclusive use of our customer and our name may be used only with prior written approval. Our reports apply only to the sample tested or inspected and do not necessarily represent the quality of other apparently similar or identical materials. All test specimens and testing conforms to ASTM A-370 requirements unless otherwise stated. This test report shall not be reproduced, except in full, without the written approval of Accu-Test Labs L.L.P.



2005 MONTGOMERY STREET - FORT WORTH, TEXAS 76107-4012
TEL: 817-737-6651 METRO: 817-429-2248 FAX: 817-737-2221

Cert No. 34-131747



Certified: 8/29/2016

Bill To

Ship To

Fore Machine
5933 Eden Street
Fort Worth, TX 76117

Ship To: 34-28830-1
Fore Machine
5933 Eden Street
Fort Worth, TX 76117

CERTIFICATION

Order No 162508	PO Number 54284	PL Number	Received 8/23/2016 3:35:24 PM
Requirements			Value
Surface Hardness Min (HRC)			32.0
Surface Hardness Max (HRC)			37.0
Qty 36	Wgt 133.704	Part No. T102146-103	Part Name Plate Set REV "CA" Job:48755-0001 PO: #Stock
		Material 4340	
Part Description Heat Treat to 145-165 KSI			
36	133.704	Total	

We hereby certify that the parts described above were given the following Heat Treatment and that the temperatures and test results were obtained with standard approved methods.

Order has been processed in accordance with all requirements of purchase order instructions.

Recorded Values	Readings
Surface Hardness Min (HRC)	32.9
Surface Hardness Max (HRC)	35.1
Quantity Inspected = (integer)	13

Processed per BPS4140G
Hardness Tested per BPS4467C

Fce#73 - Preheated @ 1000°F for 1 Hour
Fce#74 - Endo Hardened @ 1500°F for 1.25 Hours - Oil Quenched
Fce#73 - Tempered @ 1075°F for 5 Hours 5 Minutes - Air Cooled

All processes involved in the production of these articles and requiring specific process approval have been so approved and certificates are on file subject to examination.

All parts were tested in accordance with ASTM E10-15a, ASTM E18-16, ASTM E384-16, and ASTM A956-12, ASTM E-1004-09 as applicable.

Bodycote Thermal Processing - Fort Worth, Texas
NADCAP Certificate#3519165831
AS9100C Certificate#13017ASR001
Certified: 8/29/2016
By: Susan Tabor Quality Assurance

AAXON LABS, INC

4113 MURRAY AVE.
HALTOM CITY, TX 76117
(817) 514-6900

CERTIFICATION**MAGNETIC PARTICLE
INSPECTION**CUSTOMER: **FORE MACHINE CO.**P.O. #: **54804**PRIME: **BELL P/O# STOCK**AL JOB #: **90224**SUPPLIER #: **458759**CUSTOMER JOB #: **48755-0001**QUANTITY: **36**AL PROCEDURE #: **300K****2 PIECES PER SET; SN: FN000291 THRU FN000326**PART NUMBER: **T102146-103**PART NAME: **PLATE SET**MATERIAL: **4340 STEEL PER AMS6359**INSPECTED PER: **MIL-STD-1949 SUPERSEDED BY ASTM-E-1444-16e1**ACCEPTANCE CRITERIA: **LISTED BELOW**AREA EXAMINED: 100% **X** OTHER: _____TECHNIQUE REFERENCE: **N/A**

EQUIPMENT: MAGNAFLUX WET HORIZONTAL UNIT, MODEL H-720, WITH AUTOMATIC A.C. DEMAGNETIZATION, 20 IN I.D. 6 TURN COIL AND FULL WAVE DIRECT CURRENT. SYSTEM PERFORMANCE VERIFIED DAILY BY THE AS-5282 RING. EQUIPMENT CALIBRATED SEMI ANNUALLY AND SET FOR .52-.58 SECOND SHOT DURATION.

SOLUTION: **MAGNAFLUX 14A FLUORESCENT PARTICLES AND MAGNAFLUX CARRIER II.**INSPECTION RESULTS: **QTY ACCEPTED: 36****QTY REJECTED: 0**COMMENTS: **ACCEPTANCE CRITERIA:**

**ANY RATEABLE INCLUSION IS CAUSE FOR REJECTION - INCLUSIONS 1/8"
OR GREATER ARE RATEABLE.**

THIS DOCUMENT CERTIFIES THAT THE ABOVE PARTS HAVE BEEN PROCESSED IN ACCORDANCE WITH THE LISTED SPECIFICATIONS. ALL APPLICABLE TECHNIQUES AND RECORDS ARE ON FILE AND AVAILABLE FOR REVIEW.

APPROVED BY: *Gary Brothers*

LEVEL 3 INSPECTOR

DATE: **10/04/16**

EVIDENCE OF CONFORMANCE (Process)

I CERTIFY THAT THE QUANTITIES AND PARTS LISTED BELOW FOR

Fore Machine Co Inc

SHIPPED ON P.O. NO.

54847

OUR DELIVERY TICKET

250006

HAVE BEEN

Phosphate Plated

PER SPECIFICATION

MIL-DTL-16232G Ty.M Cl.2

AS ORDERED.

Oil Dip

PER SPECIFICATION

MIL-PRF-3150E

AS ORDERED.

Quantity

Part Number/Description

36

T102146-103, Job: 48755-0001

36

Total Parts for this Job

Job: 10132016-2

No tests done.

THE APPROPRIATE EVIDENCE OF PROPER MATERIALS, TESTS AND PROCESS CONTROL USED ON THE PLATING OF THE ABOVE PARTS IS IN OUR FILE FOR INSPECTION BY THE PURCHASING CONTRACTOR. WE HEREBY CERTIFY THAT THE PARTS LISTED ABOVE WERE PROCESSED TO THE ABOVE SPECIFICATIONS AND ARE NOT LIABLE FOR ANY MISLEADING INFORMATION GIVEN BY THE PURCHASING CONTRACTOR OR ANY PURCHASE ORDER.

BILLMARK COMPANY, INC.



BY:

Mark Shafer
Mark Shafer, President

2232 Solona Street

Fort Worth, Texas 76117

817-429-5356

817-834-2480 FAX

Date:

13-Oct-16

		T102146-103	48755-0001	10/19/2016
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